

Work Order ID 68881

Monday, April 25, 2011 8:38:34 AM

Page 1

Item ID: D3494-1

Revision ID:

Item Name: Stub Cover

Start Date: 4/25/2011 Start Qty: 10.00

Required Date: 4/29/2011 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3494

Rev D

100



Waterjet

FLOW CNC Waterjet

304 - 063

Memo

1-Cut as per Dwg

Dwg Rev: 5

Prog Rev: 5

2-Deburr if necessary

0.00

0.00

B 11-4-05

(14)

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

B 11-4-06

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Item ID: D3494-1

Revision ID:

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Start Date: 4/25/2011 Start Qty: 10.00

Required Date: 4/29/2011 Req'd Qty: 10.00

Reference:

Accept



Setup Start

Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

8/16/12

(44)

130

Bend as per dwg

0.00

Brake NC

Memo

0.00

Brake NC

SB 11/24/12

(14)

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

8/16/12

(44)

Quality Control

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Item ID: D3494-1

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Required Date: 4/29/2011 Req'd Qty: 10.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

144

Weld per dwg A/R S.S. rod Batch: M116577 0.00

Large Fab

Large Fab

Memo

1- WELD 11.05.12
2- GRIND AS PER DWG

0.00

(12)

EP 5/15/26

146

QC10- Inspect visual per QSI004- ground welds 0.00



QC

Quality Control

Memo

0.00

8 w/05/25

(12)

147

QC5- Inspect part completeness to step on W/O 0.00



QC

Quality Control

Memo

0.00

8 w/05/25

(12)

Work Order ID 68881

Monday, April 25, 2011 8:38:31 AM

Item ID: 103494-1

Revision ID:

Item Name: Sub Case

Start Date: 4/25/2011 Start Qty: 10.00

Required Date: 4/29/2011 Req'd Qty: 10.00

Reference:

Approvals: Process Plan:

QC:

Sequence ID/
Work Center ID

Powdercoat

Powder & coating

~~11/5/10~~

170



QC

Quality Control

Packaging

Packaging



170

Identify as per draw & check location

Memo

see

11/5/10

12

11/5/10

11/5/10

Memo

QC - Inspect Part Finish

11/5/10

11/5/10

11/5/10

11/5/10

Memo

Black Sandcoated 4.571 per 1000's 1.1

11/5/10

Operation

Set Up/

Run Hours

Tool ID

Tool #

Plan

Accept

Reject

Reject

Number

Stamp

Stop

Start

Run

Date:

Date:

SPC (Y/N):

Tooling:

Date:

Date:

Cust Item ID:

Customer:



Accept



Setup

Start

Stop



Picklist Print

Monday, April 25, 2011 8:38:31 AM

Page 1

Work Order ID: 68881

Parent Item: D3494-1

Parent Item Name: Stub Cover



Start Date: 4/25/2011

Required Date: 4/29/2011


Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A New Issue 06-05-18 JLM
IPP rev B een 888 06.12.13 EC
add welding DD 10.03.03 verifie by:EC
chg design EC verified by:DD

IPP Rev:C
Ipp RevD ECN 10-555

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA  304/316 Sheet .063		Purchased	No			100	SF	185.5000	0.72	7.578947	10		

1814-25

Location

Loc Qty

Loc Code

MAT020

185.5

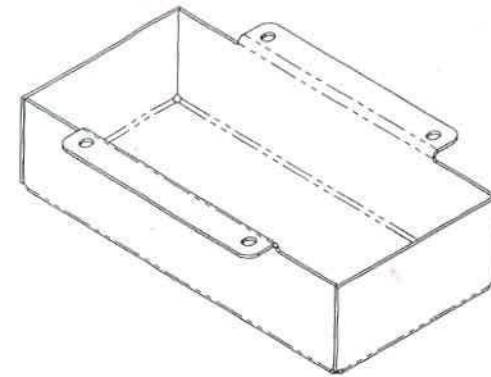
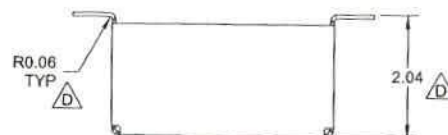
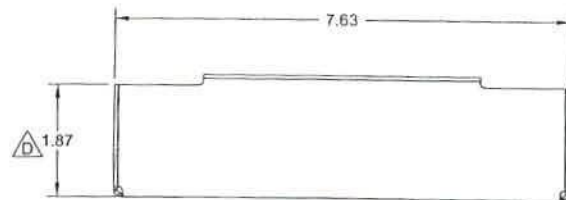
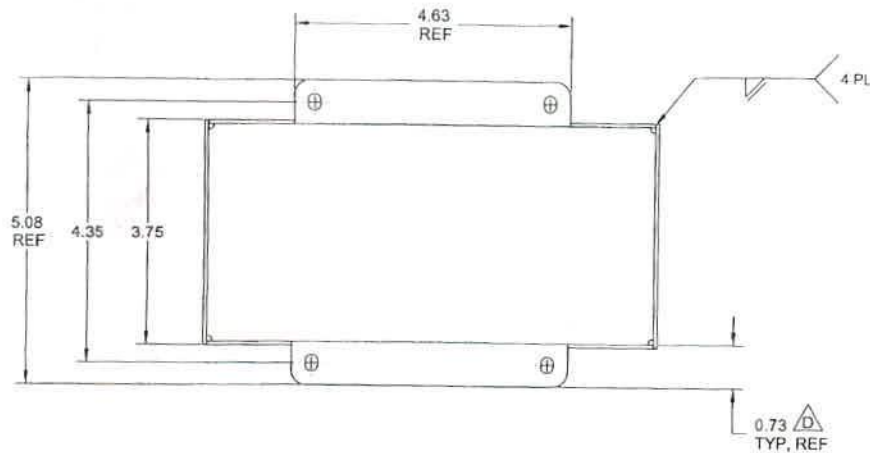
117275

185.5

117275

14

214
4.880
268
4.082



D3494-1 STUB COVER

RELEASED
2010-04-26
MD

- NOTES:
- 1) MATERIAL: MAKE FROM D3494-1F
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3494-1" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.29 lbs
 - 8) WELD PER DART QSI 004

D	TOLERANCE WAS 3 DEC PLACES (ZN B5-1); 1.87 WAS 1.88 (ZN B8-1); 2.04 WAS 2.00 (ZN B3-1); REVISED D3494-1F (ZN A6-2); CORRECTED WEIGHT INFO (ZN A8-1); UPDATED MATERIAL (ZN A8-2); REASON: SEE NCR#10-037.	MB	10.04.15
C	DRAWING TRANSFERRED TO "B" SIZE. GENERAL REVISION TO FLAT PATTERN SEE PREVIOUS REV FOR DETAILS. C8-1 DIM 5.08 WAS 5.05 AND WAS A "HARD CALLOUT". C5-1 DIM 0.87 DIM WAS 0.85, B8-1 1.90 DIM WAS 1.88 B3-1 & 2.04 DIM WAS 2.00. REFER TO PAR 08-003 FOR FURTHER DETAILS.	AJS	08.10.31
B	REVISED FLAT PATTERN. BENDING DIMENSIONS, Ø0.208 X 0.268 SLOTS WERE Ø0.208 HOLES.	MB	06.11.28
A	NEW ISSUE	MB	06.01.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.15		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3494 TITLE STUB COVER REV. D SHEET 1 OF 2 SCALE NTS COPYRIGHT © 2005 BY DART AEROSPACE LTD ALL RIGHTS RESERVED. NO PART OF THIS DOCUMENT IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.			

8.805
8.437
8.039

6.329
6.278
6.128

2.678
2.528
2.476

0.766
0.368
0

1.710
1.832
1.912

3.262
3.604

3.940
REF

7.544
7.887

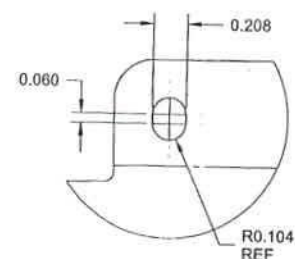
9.237
9.317
9.436

11.148

D3494-1F STUB COVER FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.060 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE COMPLETED PART WEIGHT



DETAIL A
SLOT DETAIL 4 PL
SCALE 2X

RELEASED
2010-04-26

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3494	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STUB COVER	NTS
DATE	10.04.15	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED BY THE BUSINESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

